

Date: Monday, 1/8/2007 10:53:26 AM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : ASPIRATOR |
| Job Number : 30161 | |
| Estimate Number : 11968 | |
| P.O. Number : N/A | Part Number : D2061 |
| This Issue : 1/8/2007 S.O. No. : N/A | Drawing Number : D2061 REV. A |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : PURCHASED PARTS | Drawing Revision : A |
| Previous Run : 28138 | Material : N/A |
| Written By : <u>[Signature]</u> | Due Date : 1/30/2007 Qty: 50 Um: Each |
| Checked & Approved By : <u>[Signature]</u> 07.01.08 | |
| Comment : Est: B 01.12.17 Added step 3, 4 and Inspection Level 21. SM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----|------------|
| 1.0 | PG | PURCHASING |
|-----|----|------------|

**Comment:** PURCHASING

Issue P/O: 2829

Make per Dwg D2061

Possible Supplier: Sieg's Manufacturing

Material release note required

CZ 07/01/09 (50)

| | | |
|-----|--------|-----------|
| 2.0 | D2061P | Aspirator |
|-----|--------|-----------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 ASPIRATOR BODY

| | | |
|-----|-------------|-----------------------|
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

07/01/17

| | | |
|-----|-----|-------------------|
| 4.0 | QC6 | DIMENSIONAL CHECK |
|-----|-----|-------------------|

**Comment:** DIMENSIONAL CHECK

07/01/19 (50)

| | | |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Deburr and clean to remove was residue

07/01/22 (50)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/01/24

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 1/8/2007 10:53:26 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ASPIRATOR

Job Number: 30161

Part Number: D2061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/07/01/24 (50)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

57213

12/07/01/24 (50)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/07/01/24 (50)

Job Completion



12/07/01/24

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



MAT. L:
OG3 THICK
1100 ALUMINUM

YSD 2061

sm

Sieg's Manufacturing Ltd.

604 530-7455 fax 604 530-7490
6236-205 Street, Langley, British Columbia, Canada. V2Y 1N7

07/01/19

INSPECTION REPORT

DATE: Jan 16/07
CUSTOMER: Dart Aerospace PO# 2829
INVOICE #: 30910 SUPPLIER #:

DESCRIPTION OF INSPECTION:

| PART # | QTY. | MATERIAL | CHECK HOLES | DEBUR EDGES | INSP BY. |
|--------|------|-----------|-------------|-------------|----------|
| D2060P | 50 | .063 1100 | ✓ | ✓ | JS |
| D2061P | 50 | .063 1100 | ✓ | ✓ | JS |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

NOTES OF INSPECTION: Good.

NOTES OF REJECT:



1480 Manheim Pike
Lancaster Pa 17601

CERTIFICATION OF TEST RESULTS

SOLD TO
COPPER & BRASS SALES INC
22355 WEST ELEVEN MILE ROAD
SOUTHFIELD, MI 48034

SHIP TO
COPPER & BRASS SALES INC
6555 E. DAVIDSON
DETROIT, MI 48212

CERT NO 0000598687
DATE 10/26/2004
SKID NO 322296
SKID WGT 9,760
PAGE 1 OF 1

| | | | | | | |
|----------|--------|---------|----------|--------|--------|---|
| ORDER NO | LB4176 | PO NO | C99792 | | | MILL FINISH NOT ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED |
| ITEM NO | 1 | PART NO | 050393-8 | | | |
| ALLOY | 1100 | TEMPER | O | FORM | COIL | |
| GAUGE | .06300 | WIDTH | 48.0000 | LENGTH | 0.0000 | |

LOT: 238066 COIL: B01 DROP: 440525

| INGOT | SI | FE | CU | MN | MG | CR | NI | ZN | TI |
|---------|------|------|------|------|-------|-------|-------|-------|------|
| 4405252 | 0.11 | 0.42 | 0.08 | 0.02 | 0.002 | 0.001 | 0.004 | 0.003 | 0.02 |

HEAD ULTIMATE STRENGTH 12.2 KSI
TAIL ULTIMATE STRENGTH 12.6 KSI
HEAD YIELD STRENGTH (OFFSET = .2%) 4.9 KSI
TAIL YIELD STRENGTH (OFFSET = .2%) 5.6 KSI
HEAD ELONGATION (G.L. = 2 IN) 35.5 %
TAIL ELONGATION (G.L. = 2 IN) 33.5 %

CHEMICAL COMPOSITION ACCORDING TO ASTM E-1251-04
MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-02a

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:
ASME SB209 1100 O, AMS 4001H 1100 O,
ASTM B209-04 1100 O, AMS-QQ-A-250/1 1100 O

CERTIFICATION OF TEST RESULTS SHALL NOT BE REPRODUCED EXCEPT IN FULL
** END OF CERTIFICATION **

Handwritten signatures:
Henry C. S. H. 10/26/04
C/O
Sorel
C/S

This document certifies the material above has been tested in accordance with applicable specifications described herein and has met those requirements. The material is subject to terms and conditions on the Alcoa sales order agreement.

Authorized By:

JBFF READY, LAB SUPERVISOR

16048320535

5 legs

3-24-05: 3:56PM: Copper & Brass Sales